

Work Order ID 50967

July 28, 2009 11:46:16 AM



Page 1

Item ID: D3011-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Rappel

Start Date: 31/07/2009 Start Qty: 10.00

Required Date: 04/08/2009 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

09.07.28

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3011

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks: 26.625"

*J.A 09/07/28**10*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA129

Folio Rev: *B*Dwg Rev: *B**J.A 09/08/01*

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00							
			M.A	09/08/01					
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							
			JL	09/08/05					
131 		0.00							
Outsource2 Outsource process - NDT	Memo	0.00							
	LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG d3011								
				P/010194					

rec'd + attached report

CL 09/08/10 10

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
132	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 2:30 PM								
	OVEN TEMPERATURE: 1320°								
	FINISH TIME: 3:00 PM								

MA 09 08 11 (10)

JS 09-08-12 (10)

JS 09-08-12 (10)

Picklist Print

Page 1

July 28, 2009 11:46:16 AM

Work Order ID: 50967



Parent Item: D3011-1RevB



Parent Item Name: Rappel


Start Date: 31/07/2009

Required Date: 04/08/2009

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6202RevA 		Manufactured	No			110	f	14.0000	10.0000			
I-Beam Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

14

50040

14

50630

125'

22.6666

Y.A 09/07/28

8

7

6

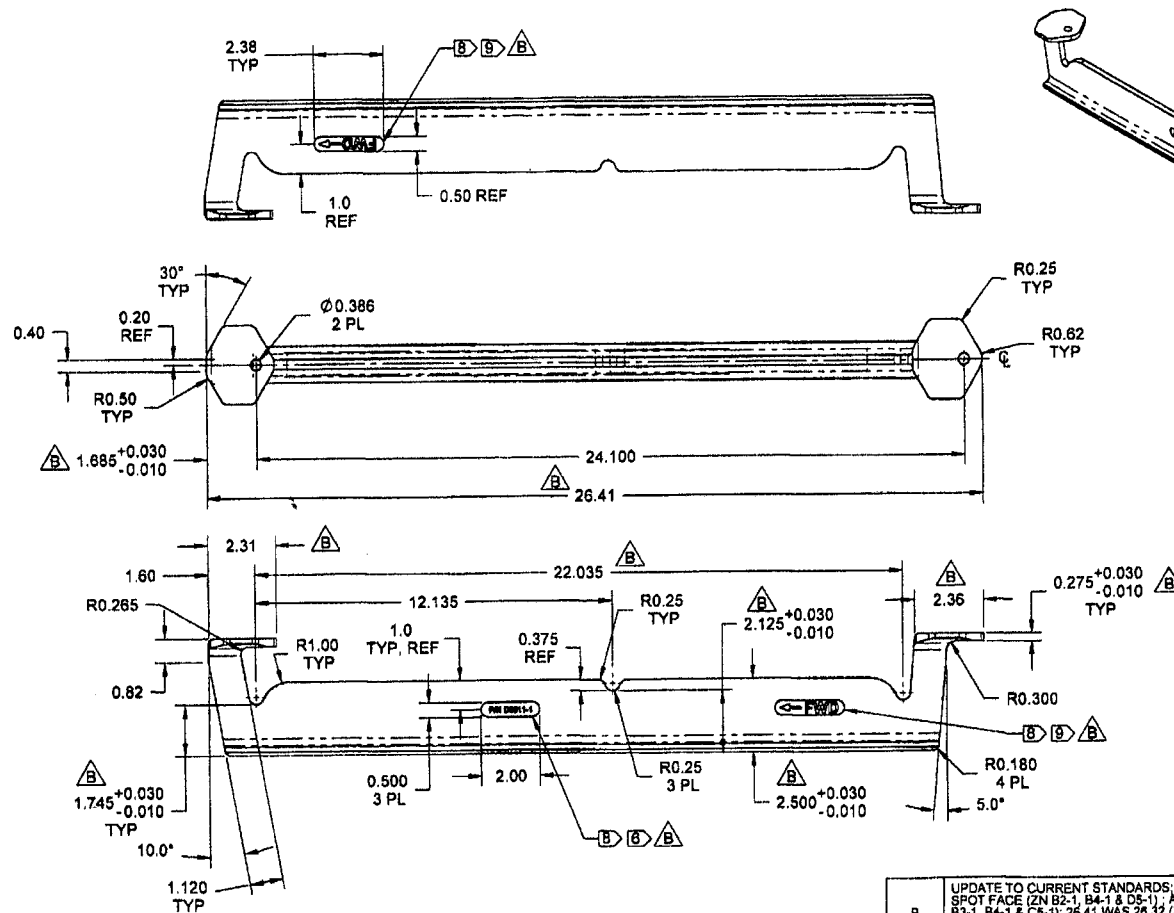
5

4

3

2

1



50967

RELEASED
09/27/85 MB

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6202-027 EXTRUSION
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.015 IN 0.19 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 3.00 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING
- 9) ENGRAVE "FWD" IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.015 IN
0.38 HIGH LETTERS WITH MIN TOOL RADIUS OF 0.015
- 10) LPI PER ASTM 1417 LEVEL 2

D3011-1 RAPPEL SLIDE BAR

B	UPDATE TO CURRENT STANDARDS; ADD NOTE 8; ADD SPOT FACE (ZN B2-1, B4-1 & D5-1); ADD DIMENSIONS (ZN B3-1, B4-1 & C5-1); 26.41 WAS 26.32 (ZN C4-1); 2.70 WAS 2.700 (ZN B7-1); ADD (+0.030/-0.010) TOLERANCES; ADD LPI (ZN A8-1)	RF	09.07.24
A	NEW ISSUE	CP	01.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. B
MFG. APPR.	DS	D3011	SHEET 1 OF 1
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	RAPPEL SLIDE BAR	NTS
DATE	09.07.24	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



LIQUID PENETRANT TEST REPORT

P- 14945

CLIENT	DART AEROSPACE	DATE	AUG-10-2009	PAGE	1	OF	
ATTENTION	LINDA CHANTAL	ACUREN JOB NO.	188-09-001484	TIME	AM	<input checked="" type="checkbox"/>	PM <input type="checkbox"/>
ADDRESS	1270 ABERDEEN ST. HAWKESBURY ON. K6H-1K7	PO/NO.	10194	WORK LOCATION	HAWKESBURY		
PROJECT	F.P.I. ON MACHINED PARTS - AND CROSS TUBES			ACCEPTANCE STD.	ASME 1417	REV./DATE	2007
ITEM(S) EXAMINED	44 STUDS. 20 RAPPELS 7 CROSS TUBES. + 12 STUDS.						

JOB DESCRIPTION	PROCEDURE NO.	LT-0002	REV./DATE	TECHNIQUE NO.	LT-TECH-2	REV./DATE	
PART NO.				MATERIAL	STAINLESS STEEL	THICKNESS	UNKNOWN
SCOPE	WET FLOUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL						

TEST DETAILS							
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED		
FAMILY BRAND	MAGNAFLUX		BLACK LIGHT S/N	16459	OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc	
PENETRANT	2L 67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER	H2O	MINIMUM DRY TIME	> 10 MIN.	OTHER	LABINO		
DEVELOPER	SKD 52	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE		
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY	DEC. 8 - 2009			

TEST SURFACE					
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)	
14 PCS STUDS - W.O. 509 33 ✓	MM 09 08 11 To BUFF AND EXAMINE - INDICATION To BUFF AND EXAMINE - INDICATIONS - 6 ITEMS TO EXAMINE AFTER BUFFING - OTHER PCS FOUND ACCEPTABLE TO STANDARD.
20 PCS STUDS - W.O. 507 21 ✓	
12 PCS STUDS - W.O. 509 32 ✓	
10 PCS RAPEL - W.O. 509 67 ✓	
10 PCS RAPEL - W.O. 509 68 ✓	
1 CROSS TUBE - W.O. 510 83 ✓	
1 CROSS TUBE - W.O. 510 84 ✓	
1 CROSS TUBE - W.O. 510 85 ✓	
1 CROSS TUBE - W.O. 508 73 ✓	
1 CROSS TUBE - W.O. 508 27 ✓	
1 CROSS TUBE - W.O. 508 00 ✓	
1 CROSS TUBE - W.O. 508 26 ✓	

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES					
CLIENT REPRESENTATIVE	CHANTAL LAVOIE	SIGNATURE	CHANTAL LAVOIE	DTR #	E-20068
TECHNICIAN (SIGNATURE):	Mike Johnston	1 ST TECHNICIAN		REPORT REVIEWED BY:	
NAME (PRINT):	Mike Johnston	2 ND TECHNICIAN		NAME	INITIALS
CGSB LEVEL	II	SNT LEVEL		CGSB LEVEL	
CGSB REG. No	6066	CGSB REG. No			